

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010741**Date Inspected:** 08-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 5 West)

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 5 West segment for smoothness. Smoothness found to be in general compliance

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**FCAW Process:**

Welding of weld joint -002 located on PCMK OBW6B, Side panel counterweight side. Welder is identified as 067876. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

FCAW Process:

Welding of weld joint -002 located on PCMK OBW6B, Side panel counterweight side. Welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

066674. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

FCAW Process:

Welding of weld joint –004 located on PCMK OBW6B, Side panel crossbeam side. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

FCAW Process:

Welding of weld joint –004 located on PCMK OBW6B, Side panel crossbeam side. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T-1.

OBG # TRIAL ASSEMBLY YARD (6BE)

FCAW Process:

Welding of weld joint –043 to 054 located on PCMK BP168-001, bottom panel T-Rib hold back area fillet weld. Welder is identified as 067947. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (6CE)

FCAW Process:

Welding of weld joint –025 to 036 located on PCMK SP647-001, Side panel T-Rib hold back area fillet weld. Welder is identified as 067942. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer